

CLAIMS

What is claimed is:

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1. A modular grill, comprising:

a plurality of bar lengths forming the rails of said grill said bar lengths having a predetermined cross-sectional shape; and

a pair of brackets for holding each said bar length in position;

wherein said bracket has a cross-sectional shape which corresponds to the cross-sectional shape of a bar length and has an end cap for dressing the end reveal of said bar length.
2. The modular grill of claim 1, wherein each said bar length is a channel-shaped member having a recurved leg at each side leg of said channel, said recurved leg forming a retaining flange.
3. The modular grill of claim 2, wherein each said channel-shaped bar length is a C-shaped channel.
4. The modular grill of claim 3, wherein each said bracket has a C-shaped channel portion which said portion slides inside of a respective end of said bar length and is held against the inside face thereof by said retaining flanges on said bar length.
5. The modular grill of claim 4, wherein bracket end cap is an end cup having an open side contiguous with the open side of said C-shaped channel portion of said bracket.
6. The modular grill of claim 5, wherein said C-shaped channel portion of said bracket is under sized to fit within said bar length, said transition of said end cup to said

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under sized portion forming a step down abutment shoulder which abuts the end of said bar length when said bracket is fully inserted therein.

7. The modular grill of claim 6, wherein said bracket also includes a flat back surface within the area of said under sized portion, said flat back surface leaving an under sized middle portion and an under sized end portion, said two under sized portions seating flush against the inside of said bar length when said bracket is fully seated.

8. The modular grill of claim 7, wherein said bracket flat back surface is connected to the respective legs of said C-shaped bracket by inclined wall sections.

9. The modular grill of claim 8, wherein said C-shaped bar length has a longer bend joining a first shorter side leg and a shorter bend joining a second longer side leg.

10. The modular grill of claim 9, wherein said bracket under sized middle and end portions cross-sectional shape conform to said bar length cross-sectional shape; and wherein a bracket flat back face extends between said inclined wall sections.

11. The modular grill of claim 10, wherein said bracket incline wall section joining said flat back face to said shorter side leg inclines at an angle of about 24 degrees.

12. The modular grill of claim 11, wherein said bracket incline wall section joining said flat back face to said longer side leg inclines at an angle of about 38 degrees.

13. The modular grill of claim 12, wherein said bracket flat back face carries at least two attachment points.

14. The modular grill of claim 13, wherein said bracket flat back face carries three attachment points.

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15. The modular grill of claim 14 wherein said bracket flat back face attachment points are each selected from the group of: extruded holes, threaded holes, rivet holes and weld points.
16. The modular grill of claim 15 wherein said bar lengths are bowed.
17. A method of making a modular grill comprising the steps of:
 - obtaining flat stock and slicing to width for rails;
 - cutting said sliced stock to length for rails;
 - cold roll forming the cross-sectional shape of said rails; and
 - cold roll forming two retaining flanges in each rail.
18. The method of claim 17 further including the steps of:
 - obtaining flat stock and slicing to width for brackets;
 - cutting to length;
 - cold rolling forming the cross-sectional shape of said brackets to conform to the cross-sectional shape of said rails;
 - stamping and punching said formed shape to form said bracket having an end cup, a under sized middle portion and an under sized opposite end portion, with a back face attachment wall between said under sized portions.
19. The method of claim 18 also further including the steps of:
 - obtaining a number of said cold formed rails;
 - selecting two brackets for each rail;
 - mounting a bracket to each end of a rail by siding said bracket onto said rail retaining flanges; and
 - mounting said rails to supports by mounting said brackets thereto.